



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5283-11
Job Sheet 182546



Part No: D5283-11 Job Qty: 10 ea
Part Name: Basket Clamp
Part Weight: 0 lbs Status: Scheduled Priority: Medium
Job Created: 8/28/18 Job Tracking No:
Due Date: 8/29/18 Created By: Patrick Lussier
Type: Stock Description:
Note: DWG REV A IPP REV:A NEW ISSUE 15-07-06 JLM VERIFIED BY:DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/29/18	8/29/18	0.00	0.00	Start Up Machining		
100	Bandsaw	10 pcs	8/29/18	8/29/18	0.00	1.23	Bandsaw1		
103	Outsource	10 pcs	8/29/18	8/29/18			MEM001 VC		
105	Purchasing	10 pcs	8/29/18	8/29/18	0.00	0.00	Purchasing		
110	Packaging	10 pcs	8/29/18	8/29/18	0.00	0.00	Packaging2		
120	QC	10 pcs	8/29/18	8/29/18	0.00	0.00	QC6		
210	Packaging	10 pcs	8/29/18	8/29/18	0.00	0.00	Packaging3-2		
220	QC21-SA	10 Ea	8/29/18	8/29/18	0.00	0.00	QC21		

Part Op 100 - CUT BLANK TO 5.200" LG
Descriptions: 103 - Issue p.o : 040867 Possible supplier: Metec Machine, Alodine and powder Coats as per Dwg C or C is required
110 - Receive & Inspect for Damage & Mat'l Certs
210 - Identify as per dwg & Stock Location:
220 - QC21- Final Inspection - Work Order Release
aug 29. 2018 x 5 RL
FINISH: 2:55.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	4.3400 ft (.434 ea)	90-Start up Operation	5098045
D5283-11P	Basket Clamp	10 pcs (1 ea)	110-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X02.000	4	3	0
110-Packaging	D5283-11P	10	0	0

Part Specifications

Specifications could not be found.

Plex 8/28/18 9:40 AM dart.Lussier.Patrick

P.T.O.

MD 18 June 2019

DQA: _____ Date: _____

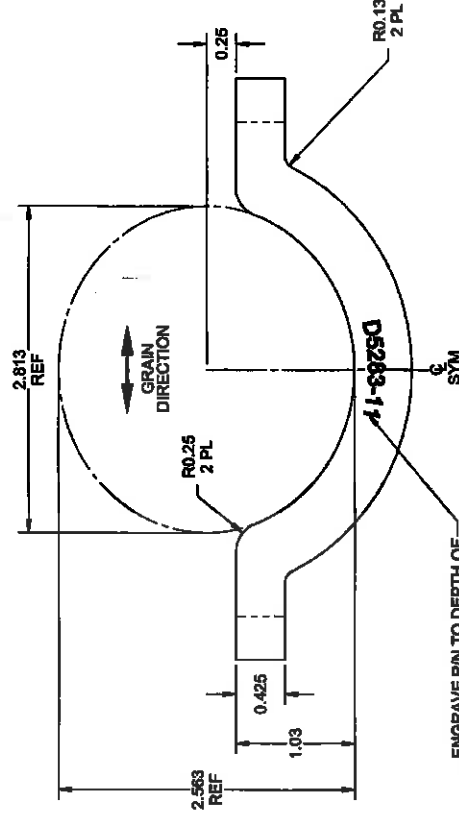
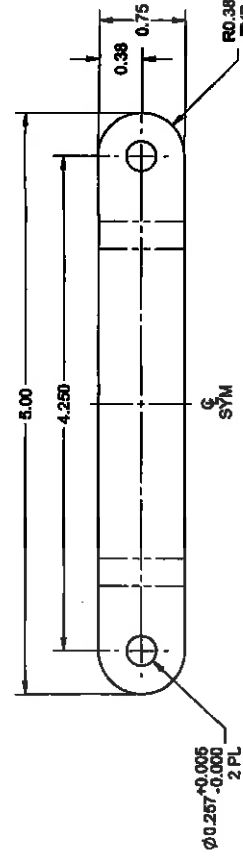
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>B2546</u>		AGAINST DEPARTMENT/PROCESS		Engineering ☐	
Part No. <u>D5283-11</u>		Cross tube ☐		Water Jet ☐	
NCR No. <u>19-7155</u>		Small Fab ☐		Prod. Eng. Coord. ☐	
Date: <u>B-08-29</u>		Thermoforming ☐		Rec/Store/Packaging ☐	
Step #: <u>120</u>		Large Fab ☐		Supplier ☒	
Description Work Order Deviation		QTY Effective: <u>5</u>		MRB (QSI042) Approval	
Disposition		Completed By <u>mk 18/08/29</u>		DAS 9 13-08-29	
Excessive chatter marks found on the inside and outside surface of clamps.		Acceptable to use buffing pad to smooth surfaces		Lead hand / Supervisor Approval Verification <u>mk 18/08/29</u>	
part supplied by Metec.		QC / QA Coordinator Approval <u>D 13-12-12</u>			
FAULT CATEGORY					
Root Cause		Temperature/Cure		Positioned Wrong	
Environment ☐		Set-up ☐		Outside Dimensions ☐	
Design ☐		BOM/Route ☐		Over/Under tolerance ☐	
Doc/Data ☐		Broken/Damage/Defect ☐		Part Incorrect ☐	
Equip/Tooling ☐		Inspection Incomplete/Unqualified ☐		Part Lost/Missing ☐	
Handling/Pre ☐		Contamination ☐		Part Moved ☐	
Material ☐		Countersink ☐		Drawing ☐	
Internal Transport ☐		Cut Too Short ☐		Finish ☐	
Tribal Knowledge ☐		Instructions Incomplete/Unclear ☐		Misread ☐	
LOA ☐		Drill Holes ☐		Turning Sequence ☐	
Substation ☐					
Past Expiry Date ☐					
Misidentified ☐					
No Re-verification ☐					
Operator ☐					
Offset/Setup ☐					
Supplier ☒					
Training ☐					
Use for Testing ☐					
Poor Information ☐					
Rushing ☐					
Product Improvement ☐					
Process Improvement ☐					
Manufacturing Process ☐					
Past Due ☐					
OTHER: ☐					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev 1



ENGRAVE PIN TO DEPTH OF
0.010 ± 0.005 IN THIS LOCATION
WITH TOOL TIP RAD OF 0.015 ± 0.005

D5283-11 BASKET CLAMP

NOTES:
1) MATERIAL: 6061-T6/T651/7050/7051/7052 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PER DART SPEC M6081 T88

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

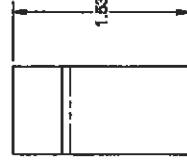
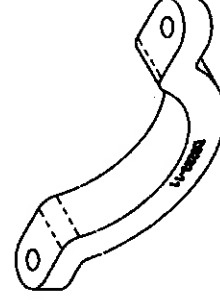
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AS D5283-11 PER QSI 044 6.3

7) WEIGHT: 0.20 lbs

8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-11_Rev A_STEP



RELEASED
2015-07-20

APPROVED

DESIGN	DB	DB	DART AEROSPACE LTD
DRAWN	DB	DB	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	AP	DRAWING NO.
MFG. APPR.	J.M	J.M	D5283
APPROVED	WM	WM	TITLE
DE APPR.	DS	DS	BASKET CLAMP ASSY
DATE	15.06.30	15.06.30	SCALE
			NTS

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PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

**PURCHASE ORDER
PO040867**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040867
PO Date: 8/28/18
Due Date: 8/29/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick
Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments: *Revision*

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182546	D5283-11P			Basket Clamp : Various STC's receive pcs	Firmed	-	8/29/18	5 Ea	0 Ea	5 Ea	\$26.20/Ea	\$131.00
Line Item Note W/O 182546									Grand Total:		\$131.00		

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 8/29/18 7:52 AM dart.Lussier.Patrick



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 23006
Date: Aug 28, 2018
Page: 1

Sold to: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO040867	Sold By: Walz, Christian D.
Shipped By: pick up	Ship Date: Aug 28, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D5283-11 Basket Clamp, no finishing ✓ DAS 9 9-89		Each	10	5 ✓	5
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____		Thank you for your order!			



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

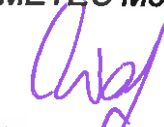
Quantity	Part Number	Part Name	Paint Batch #	P.O. Number
5	D5283-11	Basket Clamp	n/a	40867

MATERIAL: supplied by DART



We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, August 28, 2018